Work Order			in the second	*980	79*			· ;			Page 1
Revision ID:	03166-1			Accept	*N900	040	100	* Se	etup Star	1 4	S1*
		art Qty: 10.00 q'd Qty: 10.00	*10 *10	* <u>20</u> *	Cust Item I Customer:	D:				IV.	S2*
		MCS	Date: 13-04-		*	ate:	· · · · · · · · · · · · · · · · · · ·	R	an Star Stop	!/	R1* R2*
Sequence ID/ Work Center ID		eration ecription		Set Up/ Run Hours	Tool ID		Plan Code	Accept - Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr					:		*		
D3166	Rev A1									2011 Pri	
100	Skid	ltubes		0.00				20			
Large Fab		Memo Cut 3/4" x 3	3/4" square tubing 60.	0.00 (pC	13.6.5	3.					
110				0.00		100 m. 100 m. 100 m.					•.
*110 *11 0 *	BEN	NDING MACHINE -	- SKIDTUBES	0.00					en e		
CNC Bend I CNC Delta 100 Bende	er	Memo Form D316 BASB, and	66-1 Basket Hoop as p folio 18.	0.00 er Dwg D3166 using Bending	program 350	> -	- D	C 131	05/0	3	<u> </u>
120	QCe	6- Inspect dimension	s to drawing	0.00 PA	13.6.	0	,			.÷	46.
120 QC Quality Control		Memo Inspect Bas	ket Hoop dimensions	0.00 with template D3166-1-T1 (D	Г8302)				:	<u> </u>	
				¥							

Enc.

es / No				WORK ORDER NON-	CONF	ORN	ANCE / UPDAT	ΓE	DQA:	Date:	
•							•		QA Closed:	Date:	
Work Order: DISPOSITION								AGAINST DE	PARTMENT	PROCESS	·
o				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		imall Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
		- \$	Descri	ption of work order update	Init	tial	Action		Sign &		
Date	Step	Qty	•	or Non-conformance	Chief	f Eng	Description	on	Date	Verification	QC Inspector
									·		
				F	AULT (CATE	GORY				
Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in Torque W	Crimped it it Strip in Bend Vaves in E	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Ha in M M M O	ardwanspectionstructionstructionstructions (Mainte Mislabe Misread Misread Misread Misread Mut of Court of Cour	on Incomplete ons Incomplete/Uncle nance led	ear	Part Incorred Part Lost/Mi Part Moved Positioned W	st ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Date Gear Bending Centre No Cracks Crushed/Cuffs Heat Trea Inspection Ripples in Torque W	Date Step Date Step Gear Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Waves in E	Date Step Qty Gear Bending Centre Not Concentric to Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Gear General Bending Bend Centre Not Concentric to O/S Cracks Crushed/Crimped Cut Too Short Inspection Strip in Tube Ripples in Bend Drawing DISPOSITION Rework Scrap Use-as-is Work Order Update or Non-conformance Bending Bend BoM/Route Broken/Damaged Burrs Coutshed/Crimped Countersink Countersink Cut Too Short Drill Holes Drawing	PAULT Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Rework Scrap Use-as-is Work Order Update Ini Description of work order update or Non-conformance FAULT General Bend BoM/Route Broken/Damaged Ir Contamination Cuffs Contamination Ini Countersink Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Drawing Coracks Crawing Cuffo Cut Too Short Cut Too Short Cut Too Short Cut Too Short Cut Too Drawing Cut Coracy Cut Cut Too Short Cut Too Sho	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Or Non-conformance Chief Eng Bending General Bending Centre Not Concentric to O/S BOM/Route Hardward Cracks Broken/Damaged Inspection Crushed/Crimped Burrs Instruction Cuffs Contamination Mainte Heat Treat Countersink Mislabel Inspection Torque Waves in Extrusion Drawing Out of Contamination Counter Cou	DISPOSITION Rework Scrap Use-as-is Work Order Update Initial Action Chief Eng Description Date Step Qty Or Non-conformance Chief Eng Description Bending Centre Not Concentric to O/S Cracks Broken/Damaged Instructions Incomplete Instructions Incomplete Crushed/Crimped Crushed/Crimped Contamination Heat Treat Inspection Strip in Tube Ripples in Bend Dill Holes Offset DISPOSITION Rework Skid-tube Co Machining Shid-tube Grap Machining Shid-t	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance FAULT CATEGORY General Bending Centre Not Concentric to O/S Cracks Cracks Cracks Cracks Cracks Cracks Cracks Cracks Cracks Crushed/Crimped Contamination Cuffs Heat Treat Heat Treat Heat Treat Hispection Strip in Tube Rework Nachining Small Fab Machining Small Fab Machining Small Fab Composite Cromposite Chief Eng Grain Hardware Hardware Instructions Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Inspection Strip in Tube Cut Too Short Misread Offset Out of Calibration Drawing Drawing Out of Calibration	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of Work Order Update Date Date Step Qty Description of Work Order Update Date FAULT CATEGORY Gear General Bending Grain Description Date General Bending Grain Ovalized Description Date General Date Description Description Date General Date Description Description Date FAULT CATEGORY Gear General Description Description Date Grain Description Description Description Date Grain Description Description Description Date Grain Description Description Description Description Description Description Date Grain Description Desc	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Or Non-conformance Cear General

Outside Dimensions

Wave/Twist in Tube

Folio

Work Orde		979		*989	79*			Page 2
Revision ID:	D3166-1 Basket Hoop			Accept	*N900040100	* Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	4/10/13 4/10/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*	· · · · · · · · · · · · · · · · · · ·	Cust Item ID: Customer:			
Approvals:			Date:	Tooling: _ SPC (Y/N):	Date:	Rùn	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 130 *130*)	Operation Description Identify as per dwg & Stock	Location: WAY	Set Up/ Run Hours 0.00		Accept Re		Reject Insp. Number Stamp
Packaging Packaging		Memo		0.00				
140 *1 4 0*		QC21- Final Inspection - W	ork Order Release	0.00		13	16	11 +8
QC Quality Control		Memo		0.00				MF 13-6-19

NCR:	Yes / No	WORK ORDER NON-CONFOR

DQA:	Date:	

NCR: Y	⁄es	/ No				WORK ORDER NON-C	CON	IFORM	MANCE / UP	DATE			. ·	
											QA Closed:	Date	:	
Work Orde	er: _					DISPOSITION	_	AGAINST DEPARTMENT/PROCESS						
Part No.						Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR No.					Work Order Update]		Large Fab	Composite		Supplier			
Root					Descri	ption of work order update	In	nitial	Ac	tion	Sign &		,	
Cause		Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling	Ц						1							
Operator	\dashv													
Material	Н			٠.						•				
Setup	-				*									
Other	\dashv										;			
Process Supplier	Н													
Training														
Unapproved	П													
	•		·			F	AULT	CATE	GORY					
Landi	ng G	ear				General					_	_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	t Conce	ntric to	o/s	BOM/Route	-	Hardwa			Over/Under	tolerance	Temperature/Cure	
	-	Cracks				Broken/Damaged	-		on incomplete		Part Incorre	⊢	Weld	
	—	Crushed/0	Crimped			Burrs	_		ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs Contamination			4	1	Mainte			Part Moved					
	F-4 F-4			Countersink	\vdash	Mislabe		<u> </u>	Positioned V		¬			
Inspection Strip in Tube Cut Too Short						Misread	1		Power Loss/	Surge	Other			
Ripples in Bend Drill Holes				-	-	Offset								
1	Torque Waves in Extrusion Drawing			$\boldsymbol{\vdash}$		Calibration								
	Turning Sequence Finish				-		Sequence			·	· · · · · · · · · · · · · · · · · · ·			
		Wave/Tw	ist in Tul	oe		Folio		Outside	Dimensions	***************************************				

Page 1

Work Order ID:

98979

Parent Item:

D3166-1

Parent Item Name:

Basket Hoop

Start Date: 4/10/13

Required Date: 4/10/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A02.08.23New issueKJ

IPP: B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ Verified by: EC IPP Rev: C 09-01-23 as per DEO D3166-A2 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	2,125.8319	5	52.631579	6	(13-	6.5
304 SQ Tube .75x.75x.065	5W								·				
				Location		Loc Qty	<u>Lo</u>	c Code	M	12506	r&	- (105.20
		•		MAT017		460.5916						•	
		•		1240	69	460.5916							
				WA006		1665.240297							
		•		1233	03	200.503297							
				1248	80	464.737							
				1250	68	1000							

											DQA.	Date.	
NCR:	es /	No		·		WORK ORDER NON-	CON	NFORM	MANCE / UPI	DATE	QA Closed:	Date:	
Work Orde	or.				_	DISPOSITION				AGAINST DI			
Part No. NCR No.						Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Small Fab Finishing	→	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update	I	nitial	Act	ion	Sign &	-	
Cause	D	ate	Step	Qty	, (or Non-conformance	Ch	ief Eng	Descr	ription	Date	 Verification 	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
		-					AUL	T CATE	GORY				A.C.
Landi	ng Gear					General		ا ما		_	٦,	_	¬ ·
					BOM/Route Broken/Damaged		i	re on Incomplete ions Incomplete/U	Jnclear	Ovalized Over/Under Part Incorre Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	Cuf	fs				Contamination		Mainte	nance		Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G





	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECKED	APPROVED	DRAWING NO. REV.	A
	#	4	D3166 SHEET 1 OF	1
	DATE		TITLE SCAL	ĹΕ
	02.07.10		BASKET HOOP N	ITS
	_A	02.07.10	NEW ISSUE	-
į	AI de W	04.04.08	38+1-1 WAS 36.0	



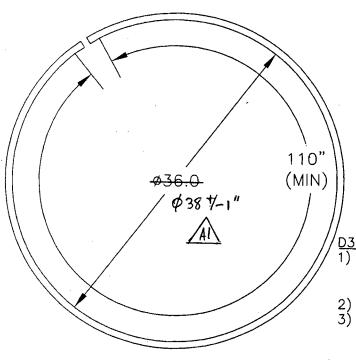


10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 60.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) FINISH: NONE3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3166-3 BASKET HOOP

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 120.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DRAWING NO	0	TITLE		551444	DADE 4-500540-			701
	0.	TITLE		, REVA1	DART AEROSPACE	LTD D.E.O. NO.	SHEET NO.	SCALE
D3166		BASKET HO	OOP		ENGINEERING ORI	DER D3166-A-2 .	1 OF 1	NTS
DRAWN	AJS		CHECKED	>	MFG. APPR.	APPROVED AND	DE APPR_#	1
DATE	08.12.1	1	DATE 08.	2.15	DATE 08/12/15	DATE 05/12-/16	DATE 08.12.16	

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING, 60.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 60.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING, 120.00" LONG REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 120.00" LONG (REF DART SPEC. M304TS0.750W.063)

SE/12/16 AP

REASON: SEE PAR 08-005

VENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT I USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT

WRITTEN PERMISSION FROM DART AEROSPACE L

••	
\(\frac{1}{2}\)	
1	
:	